

Date: Monday, 7/9/2007 11:53:02 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABIN FLOOR PROTECTOR
Job Number	: 33397		
Estimate Number	: 12765		
P.O. Number	: <u>NA</u>	Part Number	: D35744
This Issue	: 7/9/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D3574 REV.A
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 31000	Drawing Revision	: A
		Material	: <u>NA</u>
Written By	: <u>[Signature]</u>	Due Date	: 7/13/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	3 Um: Each
Comment	: Est Rev: A New Issue 07-01-22 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F60029	lexan grey
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Comment: Qty.: 16.0000 sf(s)/Unit Total : 48.0000 sf(s)

F60029 lexan sheet

Batch: M 103106

HB 07-07-12

(3)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

HB 07-07-12

(3)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-07-12

(3)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

HB 07/07/13

(3)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

HB 07/07/13 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 11/07/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:53:02 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 33397

Part Number: D35744

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/13 (B)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

P 7/7/13 (B)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(B)

Comment: FINAL INSPECTION/W/O RELEASE

En 07/07/13

Job Completion



u 07.07.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

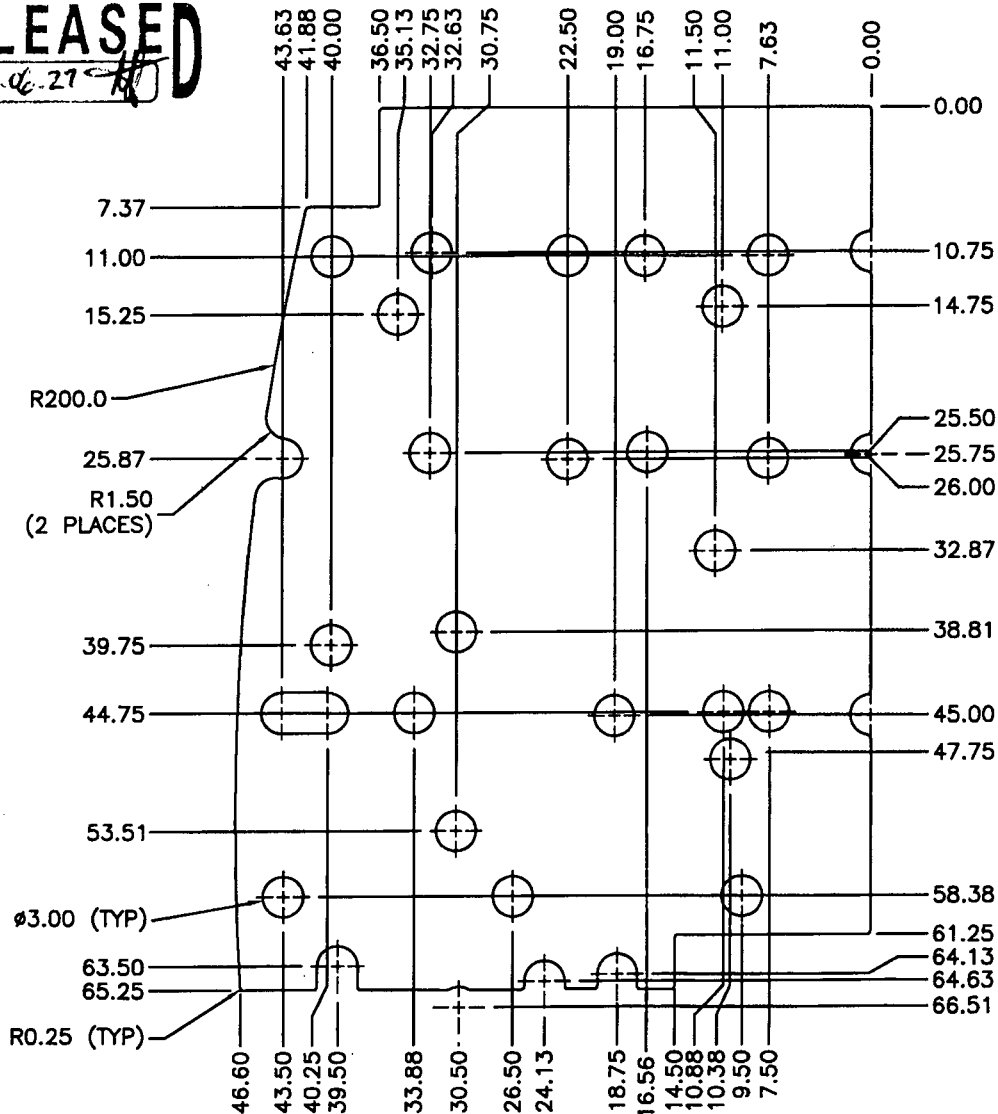
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

**RELEASED**  
07-06-27**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

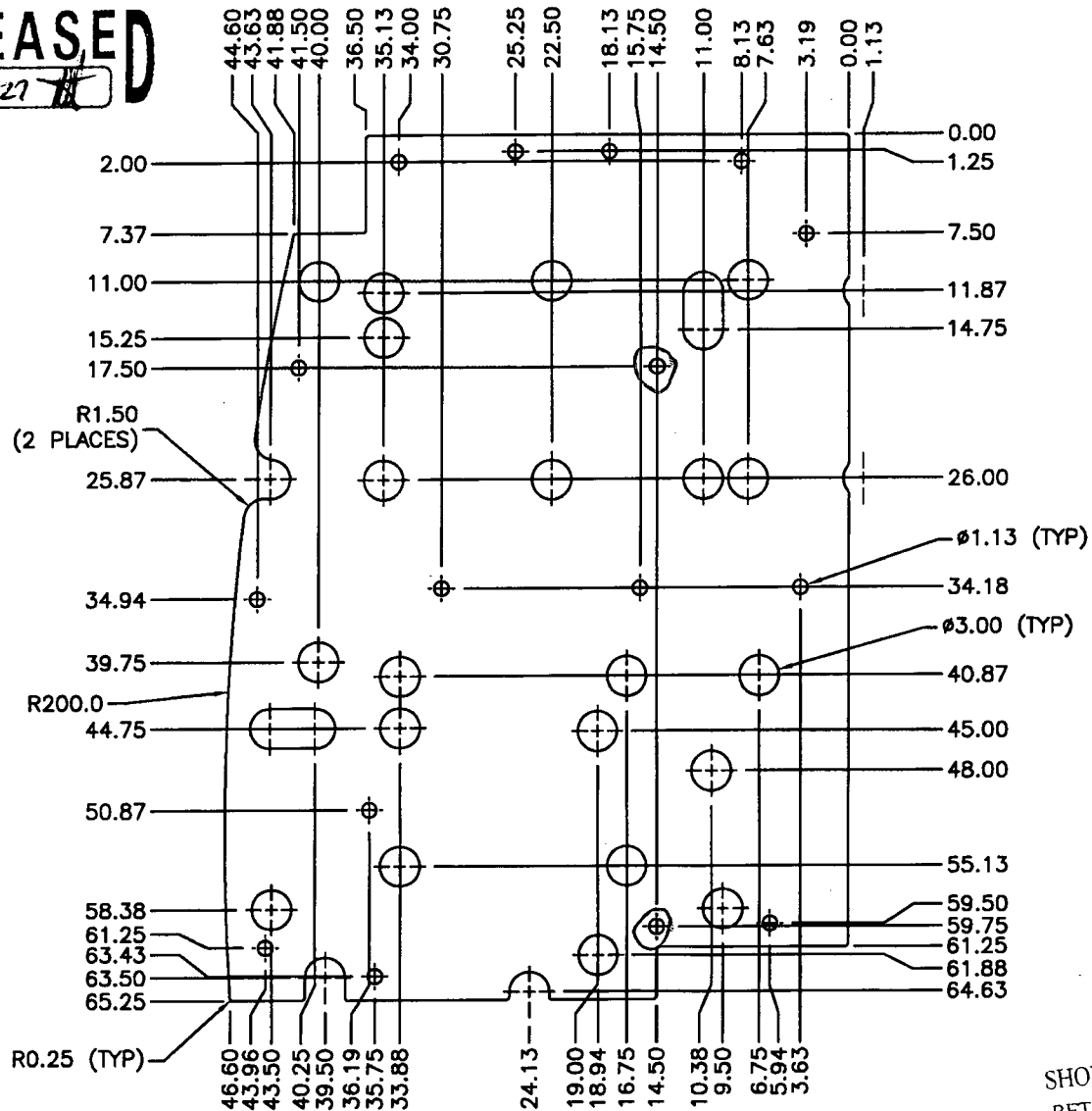
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

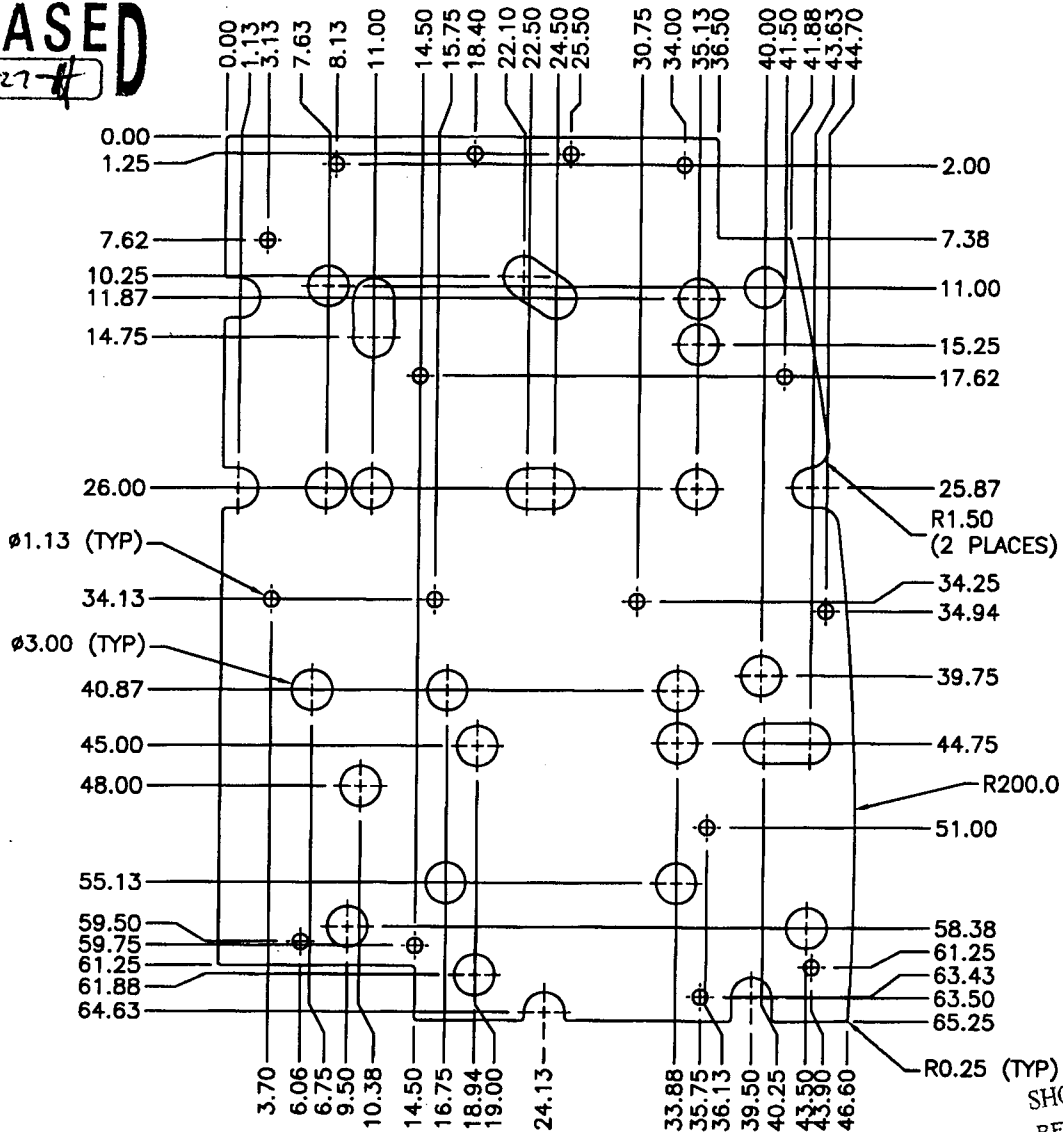
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

**RELEASED**  
07.06.27-#**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

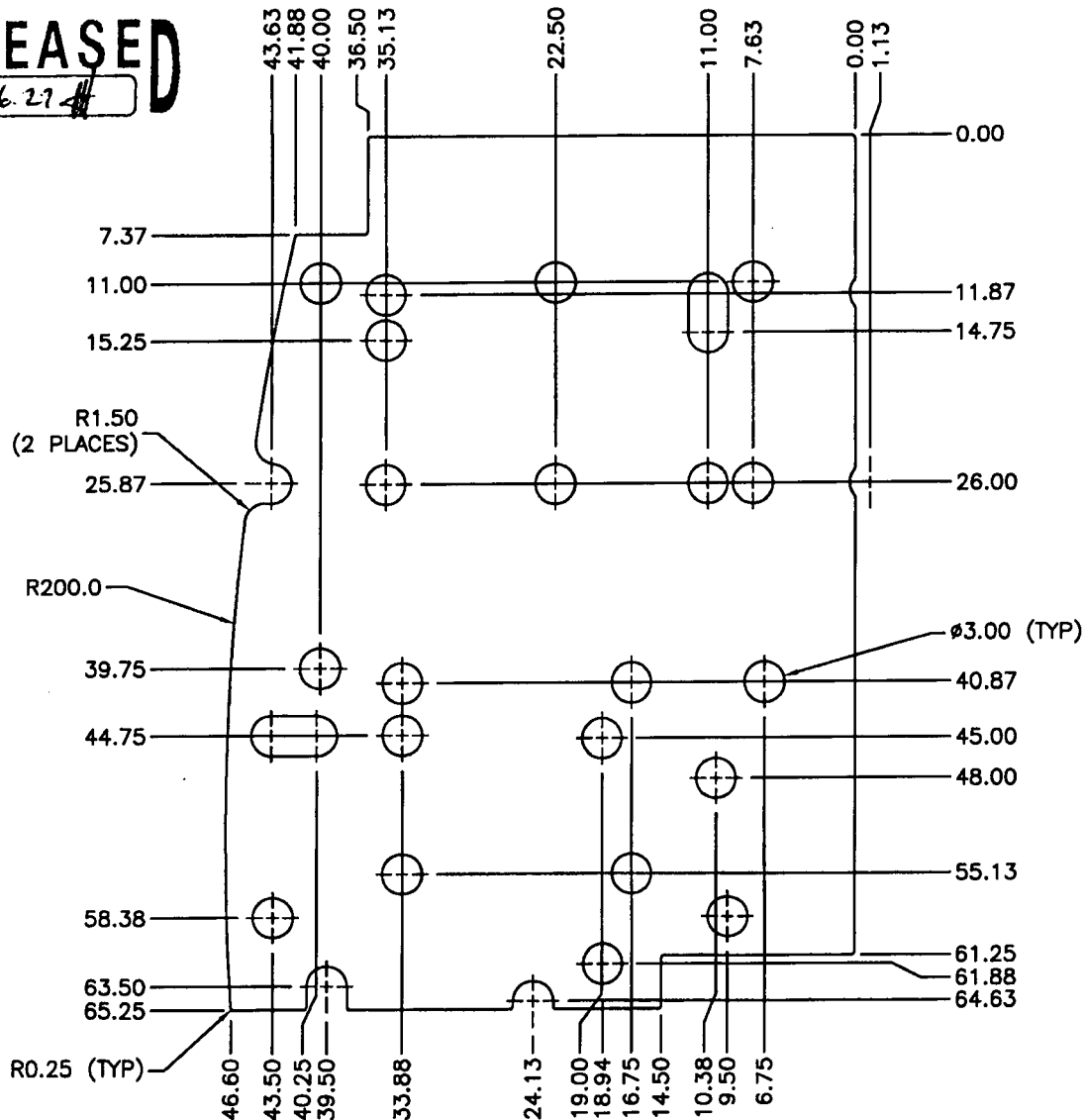
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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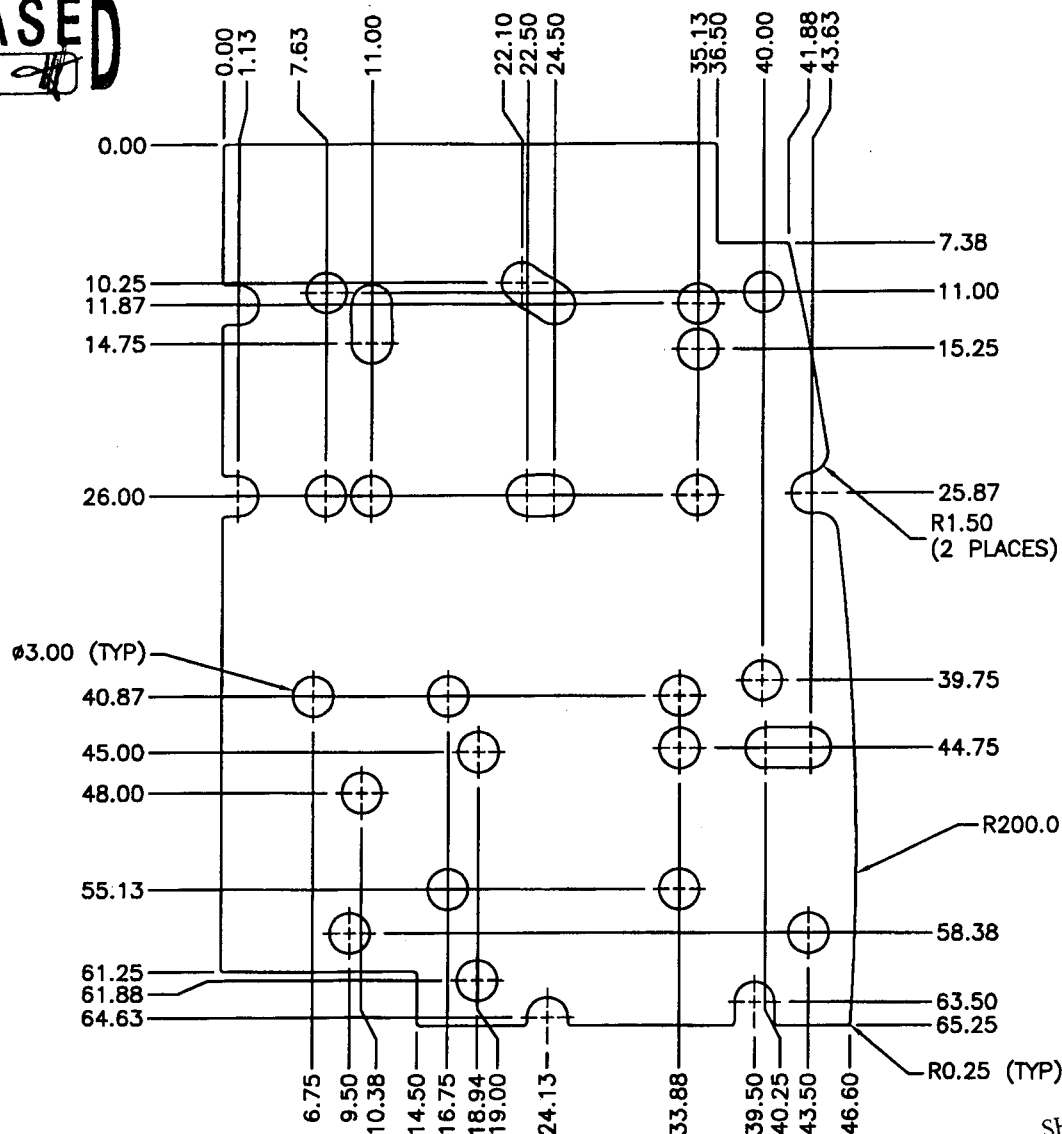
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD		Work Order: 33397
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-4
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/- .030	1.25	*			
7.62	+/- .030	7.62	*			
10.25	+/- .030	10.25	*			
11.87	+/- .030	11.87	*			
14.75	+/- .030	14.75	*			
26.00	+/- .030	26.00	*			
Ø 1.13	+0.006 -0.001	Ø 1.13	*			
34.13	+/- .030	34.13	*			
Ø 3.00	+0.006 -0.001	Ø 3.00	*			
40.87	+/- .030	40.87	*			
45.00	+/- .030	45.00	*			
48.00	+/- .030	48.00	*			
55.13	+/- .030	55.13	*			
59.75	+/- .030	59.75	*			
59.50	+/- .030	59.50	*			
61.25	+/- .030	61.25	*			
61.88	+/- .030	61.88	*			
64.63	+/- .030	64.63	*			

Measured by: LB	Audited by: SN	Prototype Approval:
Date: 07-07-13	Date: 07/07/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



DART AEROSPACE LTD		Work Order: 33391
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-4
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.70	+/- .030	3.70	✓			
6.06	+/- .030	6.06	✓			
6.75	+/- .030	6.75	✓			
9.50	+/- .030	9.50	✓			
10.38	+/- .030	10.38	✓			
14.50	+/- .030	14.50	✓			
16.75	+/- .030	16.75	✓			
18.94	+/- .030	18.94	✓			
19.00	+/- .030	19.00	✓			
24.13	+/- .030	24.13	✓			
33.88	+/- .030	33.88	✓			
35.75	+/- .030	35.75	✓			
36.13	+/- .030	36.13	✓			
39.50	+/- .030	39.50	✓			
40.25	+/- .030	40.25	✓			
43.90	+/- .030	43.90	✓			
46.60	+/- .030	46.60	✓			

Measured by: IB	Audited by: Sn	Prototype Approval:
Date: 07-07-12	Date: 07/07/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

DART AEROSPACE LTD		Work Order: 33397
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-4
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.13	+/- .030	1.13	*			
3.13	+/- .030	3.13	*			
7.63	+/- .030	7.63	*			
8.13	+/- .030	8.13	*			
11.00	+/- .030	11.00	*			
14.50	+/- .030	14.50	*			
15.75	+/- .030	15.75	*			
18.40	+/- .030	18.40	*			
22.10	+/- .030	22.10	*			
22.56	+/- .030	22.50	*			
24.50	+/- .030	24.50	*			
25.50	+/- .030	25.50	*			
30.75	+/- .030	30.75	*			
34.00	+/- .030	34.00	*			
35.13	+/- .030	35.13	*			
36.50	+/- .030	36.50	*			
40.00	+/- .030	40.00	*			
41.50	+/- .030	41.50	*			
41.88	+/- .030	41.88	*			
43.63	+/- .030	43.63	*			
44.70	+/- .030	44.70	*			

Measured by: KB	Audited by: En	Prototype Approval:
Date: 07-07-12	Date: 07/07/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	